

Work Order ID 59619

Wednesday, June 09, 2010 8:16:49 AM



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Item ID:	D2565-305	Accept		Setup	Start	
Revision ID:						
Item Name:	Strut				Stop	
Start Date:	6/9/2010	Start Qty:	5.00			
Required Date:	6/9/2010	Req'd Qty:	5.00			
Reference:						

Approvals:	Process Plan:	<i>mf</i>	Date:	10-6-9	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D2565	Rev E								

100		0.00							
	NC BRAKE								
Brake NC	Memo	0.00							
Brake NC	Punch as per Dwg D2565 using DT 8313								

SP 10/06/09

(5)

110		0.00							
	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Drill hole open to .316 Ø as per Dwg D2565 (one end only) □ Flatten both ends on hydraulic press as per Dwg D2565 □ Deburr								

= 7 m-f 10/06/17

(5X)

120		0.00							
	QC5- Inspect part completeness to step on W/O								
QC	Memo	0.00							
Quality Control									

8/06/07

(5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Item ID:	D2565-305	Accept		Setup	Start	
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Item Name:	Strut					
Start Date:	6/9/2010	Start Qty: 5.00		Cust Item ID:		
Required Date:	6/9/2010	Req'd Qty: 5.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M114841</i> Memo START TIME: <i>10:00</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>10:30</i>	0.00 0.00				<i>5</i>		<i>BR 10-6-18.</i>	
140  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>810/06/18</i>		<i>(25)</i>			
150  Packaging Packaging	Identify as per dwg & Stock Location <i>253</i> Memo	0.00 0.00				<i>10-6-18</i>		<i>(50)</i>	<i>SP</i>

Dart Aerospace Ltd

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Item ID: D2565-305

Accept

Setup Start

Revision ID:

Stop

Item Name: Strut

Start Date: 6/9/2010 Start Qty: 5.00

Cust Item ID:

Required Date: 6/9/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/21

MF
10-6-21

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Picklist Print

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Work Order ID: 59619



Parent Item: D2565-305



Parent Item Name: Strut



Start Date: 6/9/2010

Required Date: 6/9/2010

Comments: IPP: B 04.06.09 Reformat; changed Step 3 & 4 KJ/JLM

Start Qty: 5.00

Required Qty: 5.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	313.4700	2	10.52632			
 													

304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

MAT

285.6065

108498

0

114482

6.6065

114852

279

MAT017

27.8635

109314

9.33

110113

5.29

112800

13.2435

12

SB 12/06/09

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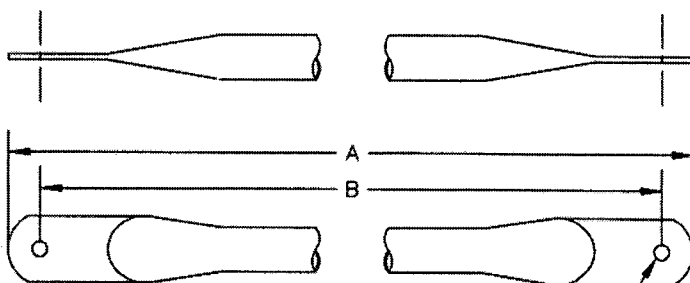
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05		TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE	
B	97.03.15	CORRECT D2565-111 DIM. A	
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)	
D	02.06.05	ADD -3XX PARTS; ADD FINISH	
E	04.05.05	ADD D2565-401-411; RMV ANGLE D	

RELEASED
04.05.05

59619



DIA 0.257 TO BE PUNCHED
"C" DIA TO BE OPENED MANUALLY

PUNCH ENDS PER SPEC CONTROL DRAWING D2638

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

GENERAL NOTES

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL
(REF DART SPEC. M304TR0.750W0.049)
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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